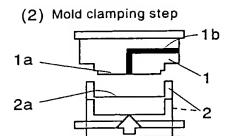
Fig.1

O



(a)

(3) Injection step in the middle of mold clamping

1
S

2

3

8

(b)

(c)
(4) Injection step after mold closure

1
2
4

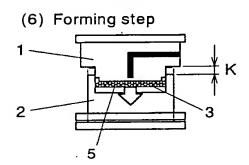
(5) Skin forming step

1

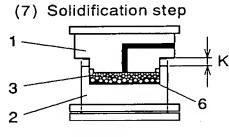
2

4

(d)

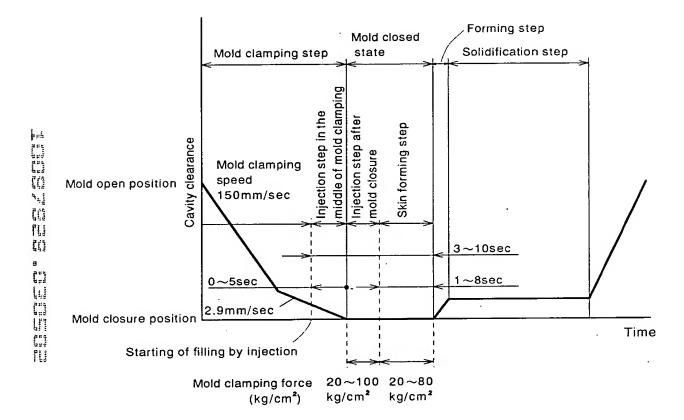


(e)



(f)





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Fig.3

